

1 10065

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 4.00 ***1***

Customer:

Run Start *NR1*

Approvals: Process Plan: *12* Date: *12-12-17* Tooling: Date:

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Draw Nbr	Revision Nbr	
D3811	Rev A	

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 23.250 " long

0.00

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA776Rev: AA & Dwg D3811 Rev: A
2-Deburr per dwg D3808

0.00

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

Memo

Quality Control

December-17-13 9:07:24 AM

Page 2

14-01-08

Work Order ID 110065

December-17-13 9:07:24 AM

110065

Page 3

Item ID: D3811-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Track
 Start Date: 12/17/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				4		761419	
Hand Finishing									
165	QC7-Inspect Chemical Conversion Coat	0.00							
165									
QC	Memo	0.00				4			
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-89

14/1/19

14/01/10 (4)

DAS
32
9-89

Work Order ID 110065

December-17-13 9:07:24 AM

110065

Page 4

Item ID: D3811-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Track

Start Date: 12/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14-01-10

14-01-10

Picklist Print

December-17-13 9:07:23 AM

Page 1

Work Order ID: 110065

Parent Item: D3811-1

Parent Item Name: Seat Track

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.500 6061-T6 Bar 1.50 x 2.50		Purchased	No			100	f	110.4660	2	8.4210528			

Location

Loc Qty

Loc Code

MAT004

110.466

103069

12

124443

14.168

124572

11.794

124681

9.342

16742

30.466

m126724

22.246

m126915

10.45

* 7.8

7.8 5/13/12-24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

DART AEROSPACE LTD		Work Order:	110065
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

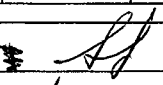
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.40	+/-0.030	0.400	✓		Vern	GA-01
6.70	+/-0.030	6.700	✓		Vern	CNC-02
0.700	+/-0.010	0.700	✓		Vern	GA-01
1.400	+/-0.010	1.400	✓		"	"
0.990	+/-0.010	0.990	✓		H-6	31006
Ø0.281 x 0.44 deep	+0.006/-0.001 x +/-0.030	Ø0.282 x 0.441	✓		Vern	GA-01
0.780	+/-0.010	0.780	✓		"	"
6.48	+/-0.030	6.480	✓		Vern	CNC-02
Ø0.196	+0.005/-0.001	Ø0.197	✓		"	"
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø0.391 x 100°	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
0.70	+/-0.030	0.700	✓		Vern	GA-01
6.44	+/-0.030	6.440	✓		Vern	CNC-02
R1.00	+/-0.030	R1.000	✓		R-6	ref.
1.576	+/-0.010	1.576	✓		Vern	GA-01
1.76	+/-0.030	1.770	✓		"	"
10.00	+/-0.030	10.000	✓		Vern	CNC-02
0.590 pitch	+/-0.010	0.590	✓		"	"
0.788 pitch	+/-0.010	0.788	✓		"	"
23.00	+/-0.030	23.00	✓		Tape	GA-12
Ø0.323	+0.006/-0.001	0.323	✓		FK-04	Vern
0.27	+/-0.030	0.27	✓		"	"
1.08	+/-0.030	1.085	✓		"	"
20.68	+/-0.030	20.67	✓		FK-05	Tape
0.44	+/-0.030	0.441	✓		Vern	GA-01
1.24	+/-0.030	1.245	✓		FK-04	Vern
0.286 x 60°	+/-0.010 x 0.5°	0.283 x 60°	✓		Vern	GA-01
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø0.391 x 100°	✓		Vern	GA-01
R0.032	+/-0.010	R0.032	✓		R-6	ref.
0.132	+/-0.010	0.132	✓		Vern	GA-01
0.315	+/-0.010	0.314	✓		H-6	31006
0.015 x 30°	+/-0.010 x 0.5°	0.025 x 30°	✓		Vern	GA-01
0.100	+0.030/-0.010	0.108	✓		Mic	GA-03
1.98	+/-0.030	1.980	✓		Vern	GA-01



DART AEROSPACE LTD		Work Order:	110065
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

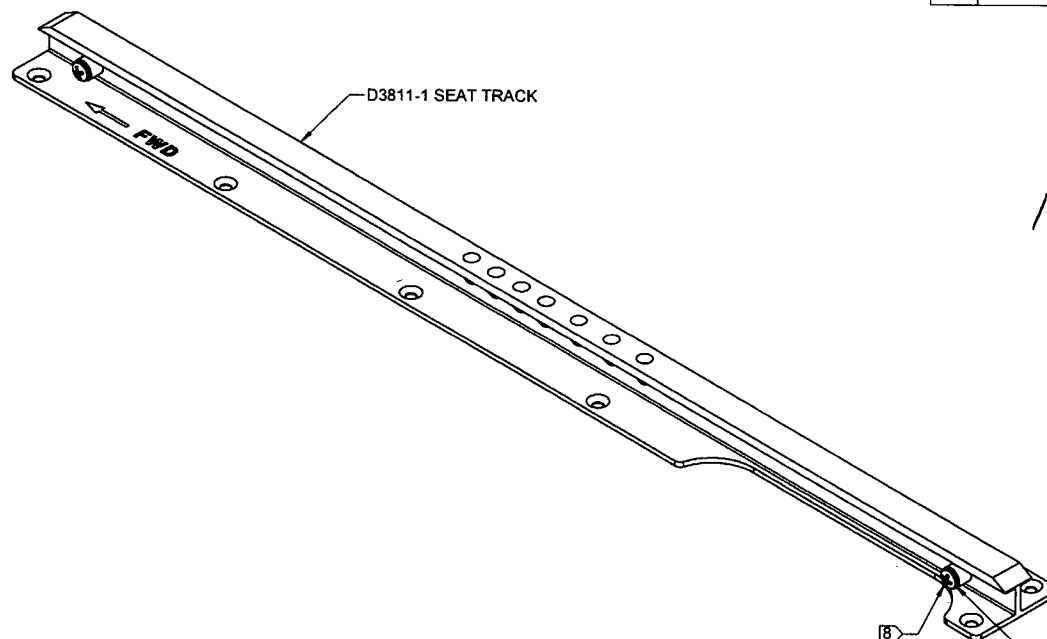
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.120	+/-0.010	0.120	✓		Mic	GA-03
0.730	+/-0.010	0.731	✓		D-6	GA-08
0.195	+/-0.010	0.193	✓		Mic	GA-03
0.630	+/-0.010	0.628	✓		"	"

Measured by: D.A. ^{FE} DAS	Audited by: 	Prototype Approval:	N/A
Date: 13/12/28 ⁰⁸ ₂₋₈₉	Date: 14-01-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ 	

QTY -041	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



110065
PL13-12-17

D3811-041 SEAT TRACK ASSEMBLY

RELEASED
08-03-30/17

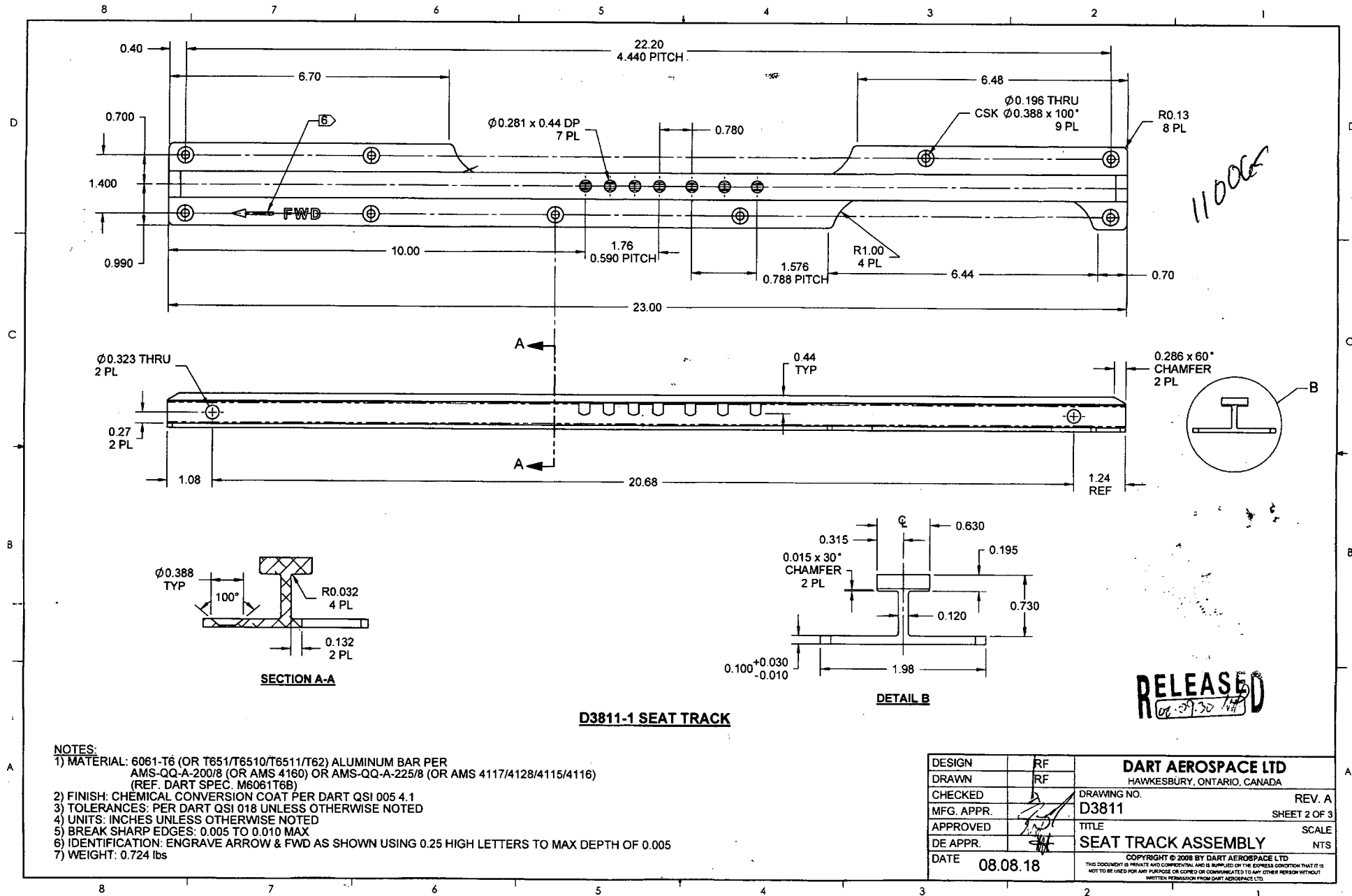
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

A	NEW ISSUE	RF	08.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	B		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.18		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3811	SHEET 1 OF 3
TITLE	SEAT TRACK ASSEMBLY	SCALE
		NTS




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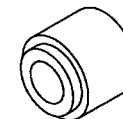
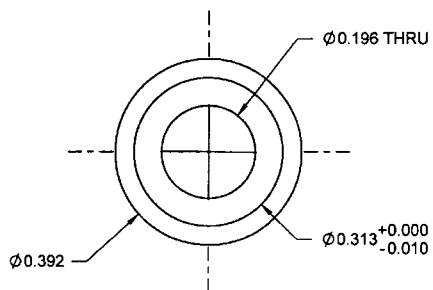


D3811-1 SEAT TRACK

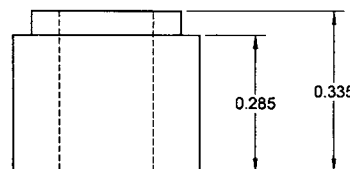
NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.25 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.724 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D3811	REV. A SHEET 2 OF 3
DRAWN	RF			
CHECKED		DATE 08.08.18	TITLE SEAT TRACK ASSEMBLY	SCALE NTS
MFG. APPR.				
APPROVED		DATE 08.08.18	TITLE SEAT TRACK ASSEMBLY	SCALE NTS
DE APPR.				
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110065



D3811-3 BUSHING

RELEASED
68-04-30-116

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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